DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-002934
Date Inspected: 02-Jun-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works, Ltd.

OSM Arrival Time: 2230
OSM Departure Time: 830
Location: Muroran, Japan

CWI Name:	N/A		**CWI Present:**	☐ Yes	☑ No
Inspected CWI report:	☐ Yes	☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No ☐ N/A
Electrode to specification:	☑ Yes	☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No ☐ N/A
Qualified Welders:	☑ Yes	☐ No ☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No ☐ N/A
Approved Drawings:	☑ Yes	☐ No ☐ N/A	**Approved WPS:**	☑ Yes	☐ No ☐ N/A
			Delayed / Cancelled:	☐ Yes	☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes was present during the repair welding of the Saddle Casting. The following was observed:

Foundry Shop

At the start of the shift the QA inspector traveled to the Foundry Shop to observe the continued repair welding of the ribs on the West Deviation Saddle identified as W2E1. The QA inspector also observed that Japan Steel Works, Ltd. had relocated the saddle casting to Lane Number 1 to the designated area identified as, “The Gouging and Grinding Area.”

The QA inspector observed the welding performed by Japan Steel Welding, Ltd. (JSW) welding personnel Kazuya-Komai on the rib 2L with the repair area identified as 3-8. The welder, Kazuya-Komai performed the repair welding in the horizontal (2G) position with the work in the vertical plane and the axis of the weld horizontal and utilized the Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) identified as SJ-3026-2. The consumable utilized by the JSW welder appeared to be a Hobart Brothers Product identified as LB-106, with the diameter size of 5.0 mm which appeared to comply with the AWS Specification A5.5 and the AWS Classification E10016-G.

At the conclusion of verifying the preheat temperature of 195 degrees Celsius at the weld repair area, the QA inspector verified the Alternate Current (AC) welding parameters. The welding parameters appeared to be as follows; 208 AC amps and 25 C volts with a travel speed measured at 140.6 millimeters per minute (mm/m).

Later during this shift the QA inspector, at random intervals verified the welding parameters, minimum and maximum surface temperatures and observed the in process repair welding of the rib identified as 2L.

WELDING INSPECTION REPORT

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QA Observation Summary

This QA inspector randomly observed the in process Shielded Metal Arc Welding (SMAW) for the repair welding of the rib on the West Deviation Saddles identified as W2E1. This QA inspector noted that it appeared the approved and latest revised WPS's were posted at the appropriate welding station and that each approved welder was entered in the latest revised Welding Personnel Log issued by Japan Steel Works, Ltd. The welding parameters, preheat and interpass temperatures were verified as noted by this QA inspector utilizing a Fluke 337 clamp meter for the electrical welding parameters and Tempilstik temperature indicators for preheat and interpass temperatures. The filler metal utilized at the welding stations was also verified. The welding and inspection was not completed during this shift and appeared to be in general compliance with the contract documents.

The following digital photograph illustrate the observations of the activities performed on this date.

Summary of Conversations:

There were no conversations relative to this project on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer